

Date: Wednesday, 10/09/2008 3:46:39 PM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	BRACKET
<b>Job Number</b> :	41958		
<b>Estimate Number</b> :	13265		
<b>P.O. Number</b> :		<b>Part Number</b> :	D37781
<b>This Issue</b> :	10/09/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D3778 REVA
<b>First Issue</b> :	/ /	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	39283	<b>Drawing Revision</b> :	A
	<b>Type</b> :	<b>Material</b> :	
	SMALL /MED FAB	<b>Due Date</b> :	25/09/2008
<b>Written By</b> :		<b>Qty:</b>	12
		<b>Um:</b>	Each
<b>Checked &amp; Approved By</b> :	JUD 08-9-11		
<b>Comment</b> :	Est Rev:A new issue 08-04-15 DD verified by:EC Est Rev:B 08-05-14 revA as per ECN1171 DD verified by:EC Est Rev:C 08-05-22 add powder coating DD verified by:ec		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M5052H32S090	5052-H32 .090 Sheet
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**Comment:** Qty.: 0.0981 sf(s)/Unit Total : 1.1768 sf(s)  
 5052-H32 Aluminum sheet, 0.090" thick  
 Batch: 100782 IB 8-9-17

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

1-Cut as per Dwg D3778

Dwg Rev: A

Prog Rev: A

\*\*\*\*grain direction along 2.34" \*\*\*\*

2-Deburr if necessary

IB 8-9-17

IB 8-9-17

(16)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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IB 8-9-17

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

S 08/09/17 (+10)

5.0	BRAKE NC	NC BRAKE
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**Comment:** NC BRAKE

1-deburr

1 sep. 2.0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 10/09/2008 3:46:39 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 41958

Part Number: D37781

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Bend as per Dwg D3778

SB 08/09/30

(10)

6.0

QC5

INSPECT WORK TO CURRENT STEP



08/10/01 (16)



Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

MS 08-00-02

X16

8.0

POWDER COATING

POWDER COATING



M 10 5642



(16X)

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

12:30  
325°F  
1:00

M-L 08/10/03

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FD 08/10/03 (16)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 229

AS 08/10/06 X16

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/06

Job Completion



W 08.10.06

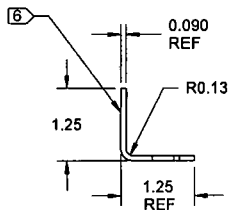
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

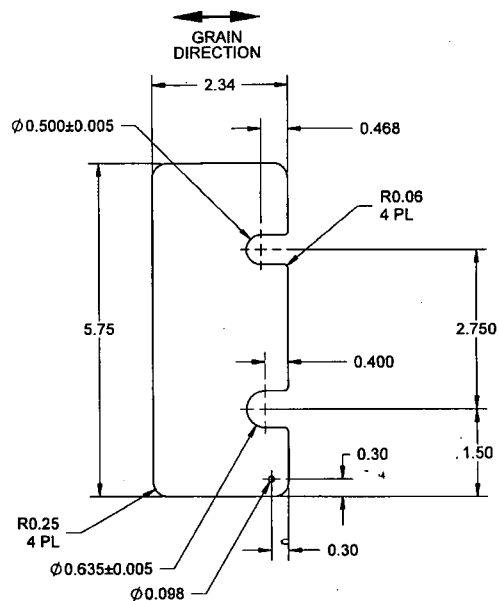
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

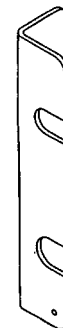
**NOTE:** Date & initial all entries



**D3778-1 BRACKET**



**D3778-1F FLAT PATTERN**



RELEASED  
08.05.11

**NOTES:**

- 1) MATERIAL: 5052-H32 ALUMINUM SHEET, 0.090 THICK PER AMS-QQ-A-250/8 OR AMS 4016 (REF DART SPEC M5052H32.090) OR 6061-T6/T62 ALUMINUM SHEET, 0.090 THICK PER AMS-QQ-A-250/11 OR AMS 4025/4027 (REF DART SPEC M6061T60.090)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT BLACK SANDEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3778-1" USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH

REV.	NEW ISSUE	DESCRIPTION	PH	08.04.11
DESIGN	PH		BY	DATE
DRAWN	PH			
CHECKED	PH			
MFG. APPR.	PH			
APPROVED	PH			
DE APPR.	PH			
DATE	08.04.11			

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3778** REV. A  
SHEET 1 OF 1

TITLE **BRACKET** SCALE NTS

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